

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014090**Date Inspected:** 09-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Yu Dong Ping/ Mr. Liu Yang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 054069 perform FCAW Buttering welding on, Shear diaphragm plate and Weld joint identified as WD1-A 22. ZPMC CWI Identified as Mr. Liu yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-Repair.(Photo attached)

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 500373, 500363 perform SMAW welding on, South tower, Lift 5 and Weld joint identified as SSD1-TL5-1B/F-2A, 35A. ZPMC CWI Identified as Mr. Gao Zhi Chun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-B-U3C.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053869 perform FCAW welding on, Skin E Support plate of South tower, Lift 4 and Weld joint identified as SSD1-FESA3-1C/D-7. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4132.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 0500373

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

perform SMAW welding on, South tower Skirt plate Base to flange and Weld joint identified as SD1-A 440 D/E-10. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114.

Bay no. 11

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 251194 perform SMAW welding on, Web to stiffener on spare strut of North tower and Weld joint identified as ND1-STSA4-6-135mtr.-1-19. ZPMC CWI Identified as Mr. Yu dong ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2113.(Photo attached)

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as Nort tower, Lift 4, BC Corner diagonal plate butt joints at Bay no. 10 . The weld designation reviewed is as follows:

NSTL4 – 3 D/L- Jt. nos – 24, 55, 58, 28, 23, 48, 20, 49 – BC Corner diagonal plate

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
----------------------	---------------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------
